












Date: Wednesday, 26/11/2008 12:45:57 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 43747	
Estimate Number : 10964	
P.O. Number :	Part Number : D2565301
This Issue : 26/11/2008 S.O. No. :	Drawing Number : D2565 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 40680	Material :
Written By :	Due Date : 10/12/2008 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 08.11.26</u>	
Comment : Est: A 02.06.10 New Issue NG	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304TR0750W049 304 RD Tube .750 x .049W
	 
Comment: Qty.: 2.3888 f(s)/Unit Total: 14.3325 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No: <u>M 11027.5</u> <u>M 109314</u> <u>1</u> <u>8809/01/07</u> <u>(6)</u>	
2.0	BRAKE NC NC BRAKE
	 
Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313 <u>8809/01/07</u> <u>(6)</u>	
3.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr <u>FF 09-01-08</u> <u>M-1 09/01/08</u> <u>(6X)</u>	
4.0	QC5 INSPECT WORK TO CURRENT STEP
	 
Comment: INSPECT WORK TO CURRENT STEP <u>S 09/01/08</u> <u>(6)</u>	
5.0	POWDER COATING POWDER COATING
	 <u>M 109996</u>  <u>(6X)</u>
Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 START TIME: <u>10:15</u> OVEN TEMPERATURE: <u>400 °F</u> FINISH TIME: <u>10:45</u> <u>M-1 09/01/09</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

Job Number: 43747

Part Number: D2565301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HS



Comment: INSPECT POWDER COAT

09-09-01

KG

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 253.

88

09/01/12

KG

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

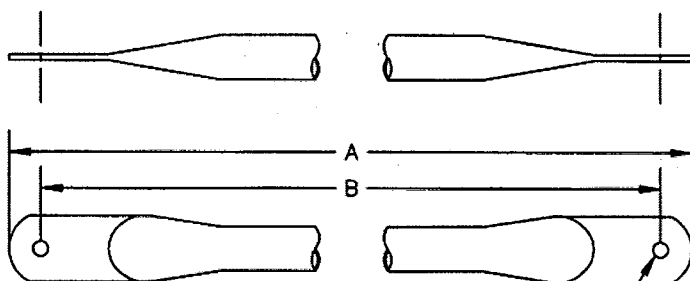
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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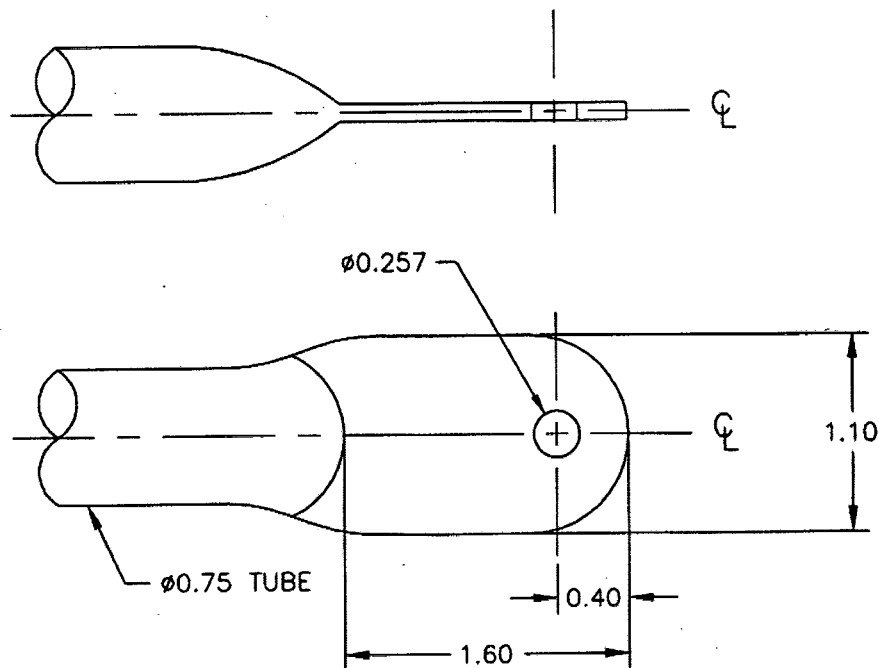
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MID	APPROVED [Signature]	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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